

Work Order ID 60765

Thursday, July 22, 2010 10:52:50 AM

Page 1

Item ID: D350-591-311

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long LH

Start Date: 7/22/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 7/29/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-7-21

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG002 ✓

8/10/08/17

10-7-21

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R □ Aluminum Rod □ M112860
M114242

3-Grind End Plate flush

10-08-04 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
						10.09.04			
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
						S 10.08.04			
						(x4) CH			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
						10.08.04			
						24			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SAD
10-08-09

(4)

P

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

- 1-Assemble Leg Assembly as per Dwg D3272.
- 2-Leave one rivet out until welding is complete.
- 3-Bevel Aft end for welding
- 4-Inspect for foreign object as per QSI 024
- 5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod M112860
- 6-Grind End Plate flush
- 7-Install last rivet as per Dwg.

H 10.08.09

4 P

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

④ PD 10.08.09

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.10.08.09

④
41

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

- ml 10 08 10 ④

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Required Date: 7/29/2010 Req'd Qty: 4.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250  Packaging	Pick Kit	0.00							
	Memo	0.00							
	Packaging								
260  QC	QC4- 100% Inspect kits for completeness	0.00							
	Memo	0.00							
	Quality Control								
270  Packaging	Packaging	0.00							
	Memo	0.00							
	Packaging								
	Identify and pack for shipping as per PPD350-591-311								
	Location: <u>70</u>								

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 7/29/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/18
mf
10-8-17

W/O:		WORK ORDER CHANGES					
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Page 1

[illegible]**Required Date:** 7/29/2010

Required Qty: 4.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSI 9410-011  Step Modification	CHG082	Manufactured	No				Each	2.0000		4		10/4/17 SL	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG020				2					
				59257				2					
D3067-1  End Plate		Manufactured	No			110	Each	21.0000		1	4	10.08.09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				21			4		
				59596				21					
D3219-1  Plate		Manufactured	No			110	Each	73.0000		2	8	10.08.09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				73			8		
				59597				73					
D3272-1  Step		Manufactured	No			110	Each	15.0000		1	4	10.08.09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				15			4		
				59971				10					
				59972				5					

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Picklist Print

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Page 2

Work Order ID: 60765

Parent Item: D350-591-311


Parent Item Name: Heli-Access-Step, Long LH


Start Date: 7/22/2010

Required Date: 7/29/2010


Start Qty: 4.00


Required Qty: 4.00

D3065-041 Manufactured No 180 Each 34.0000 1 4  PL10.08.09


 Step Leg Assembly Hi


Location	Loc Qty	Loc Code
WA	34	
58536	4	
59678	30	

D3066-1 Manufactured No 180 Each 143.0000 2 8  PL10.08.09


 Spacer


Location	Loc Qty	Loc Code
WA	143	
58540	77	
60194	66	

D3067-1 Manufactured No 180 Each 21.0000 1 4  PL10.08.09

 End Plate

Location	Loc Qty	Loc Code
WA	21	
60141	21	
59596		

MS20600-AD4W4 Purchased No 180 Each 627.0000 16 64  PL10.08.09

 Rivets

Location	Loc Qty	Loc Code
ST321	627	
113368	62	
114181	11	
114718	2	
114935	552	

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Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 60765

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 4.00

Required Qty: 4.00

AN3-35A

Purchased

No

250

Each

157.0000

2

8

Bolt

Location

Loc Qty

Loc Code

ST353

157

115016

57

115108

100

AN4-13A

Purchased

No

250

Each

1,082.000

8

32

Bolt

Location

Loc Qty

Loc Code

ST357

582

114941

82

115108

500

ST358

500

115159

500

AN5-36A

Purchased

No

250

Each

203.0000

2

8

Bolt

Location

Loc Qty

Loc Code

ST341

203

114292

5

114941

198

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

16

Washer

AN960JD416

NAS1149D0463J

Purchased

No

250

Each

0.0000

16

64

Washer

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Page 3

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Page 4

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Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 4.00

Required Qty: 4.00

AN960JD516 NAS1149D0563J Purchased No

250

Each

0.0000

4

16

Washer

D2230-3

Manufactured No

250

Each

35.0000

4

16

Lug

Location

Loc Qty

Loc Code

ST476

35

55452

2

59115

1

59418

32

D2618

Manufactured No

250

Each

105.0000

2

18

Bushing

Location

Loc Qty

Loc Code

ST019

103

59425

3

60193

100

ST020

2

56892

1

57829

1

D2856-400

Manufactured No

250

f

362.2188

0.6

2.4

Abraison Strip

Location

Loc Qty

Loc Code

ST403

362.2188421

56626

146.218842

59920

216

x2 @ 7.20" long → measured 8/10/03/17

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 4.00

Required Qty: 4.00

D3235-1 Manufactured No 250 Each 43.0000

8
+4
Mounting Lug

2 8
10/8/1088

Location Loc Qty Loc Code

ST471 43
59125 43

D3278-041 Manufactured No 250 Each 70.0000

8
+4
Support Assembly

1 2
10/8/1088

Location Loc Qty Loc Code

ST471 70
59633 30
60201 40

MS21042L3 Purchased No 250 Each 2,606.000

8
+4
Nut

2 8
10/8/1088

Location Loc Qty Loc Code

ST300 2606
114523 130
114718 476
114784 2000

MS21042L4 Purchased No 250 Each 3,911.000

8
+4
Nut

8 32
10/8/1088 (40)

Location Loc Qty Loc Code

ST300 3911
113422 68
114523 28
114718 23
114784 1792
115108 2000

32

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Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 4.00

Required Qty: 4.00

MS21042L5

Purchased

No

250

Each

821.0000

2

8



Nut



10/8/10 SP

40

Location

Loc Qty

Loc Code

ST139

321

114813

321

ST300

500

115156

500

8

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DART

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

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Dart Aerospace Ltd

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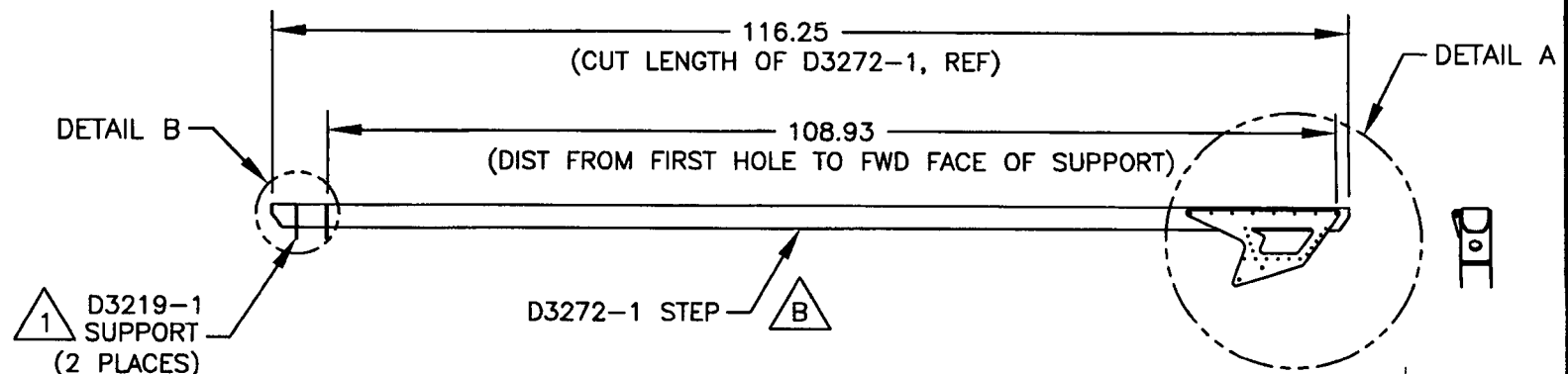
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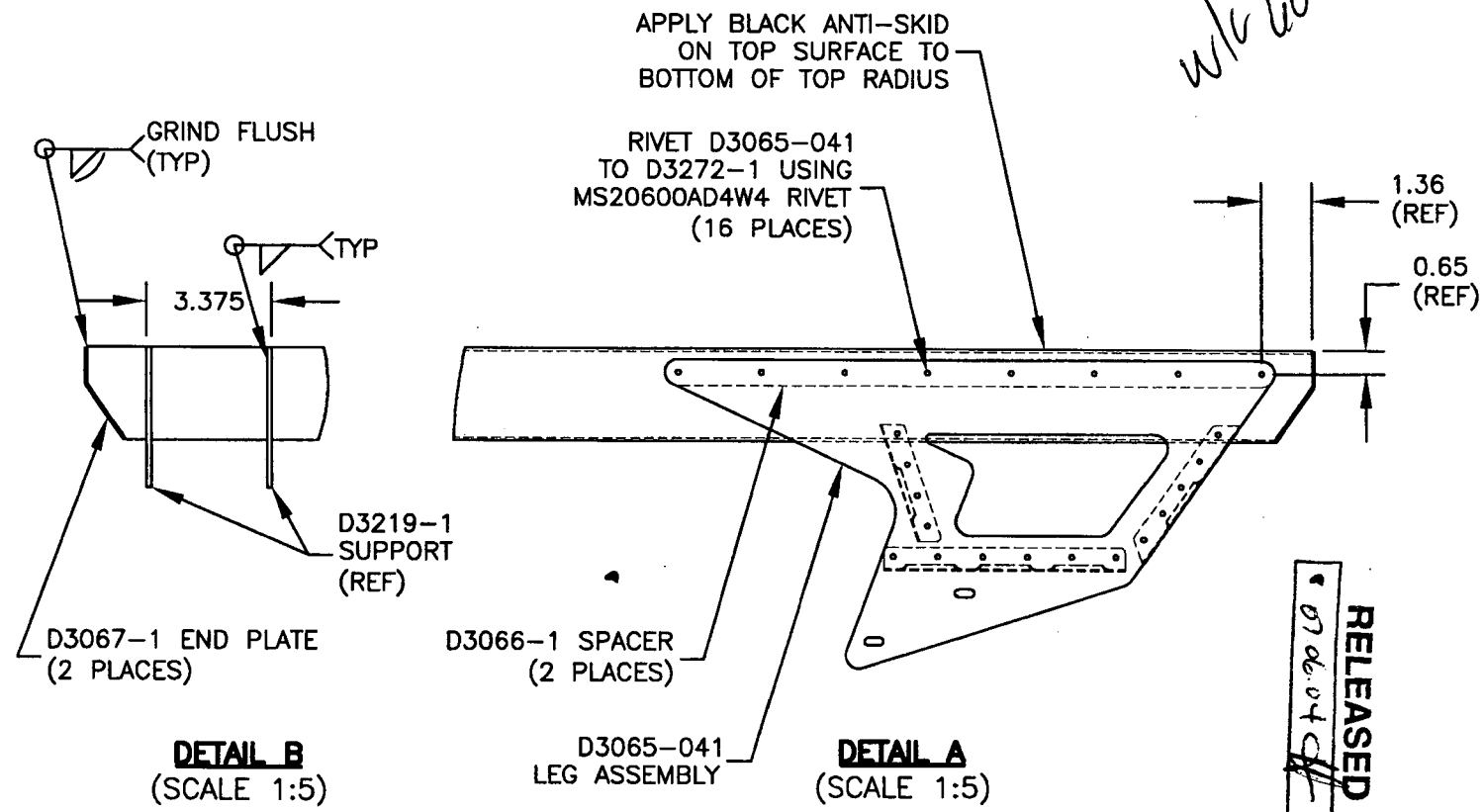
NOTE: Date & initial all entries



DESIGN	90	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	CE	APPROVED	CE	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	D3272	REV. B
			STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07.06.04

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

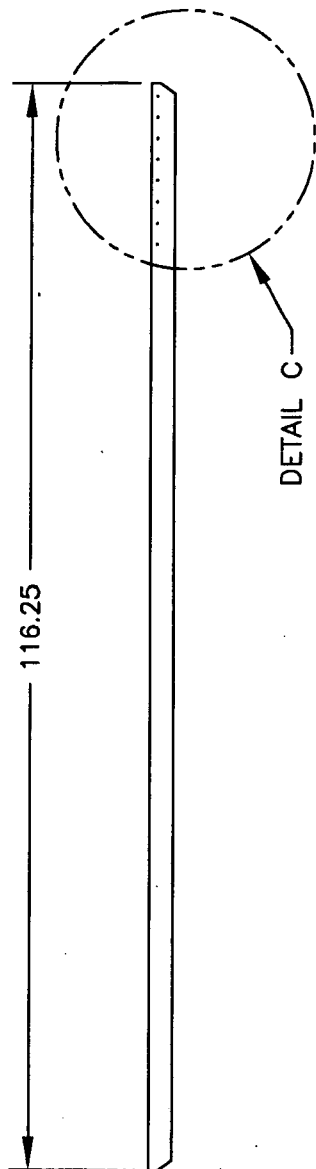
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

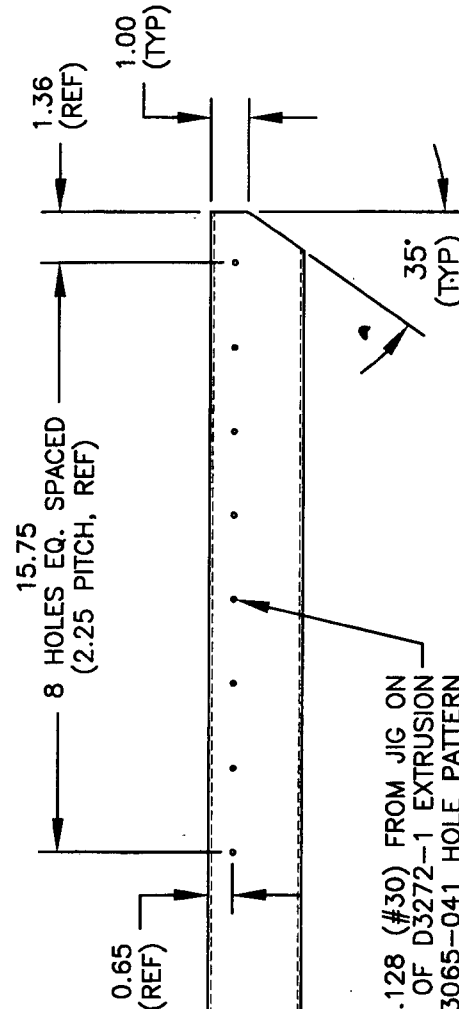


DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)

57207 g/m



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.